



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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JUL 31 2018

104880

D022-661-011
Job Sheet 181309



Part No: D022-661-011

Job Qty: 1 ea

Part Name: R22 Bearpaws



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/25/18

Job Tracking No:

Due Date: 8/15/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A1-IPP Rev:C 04.02.19 Added tolerance and ref to DSK086-12 to Step 3 KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	8/15/18	8/15/18	0.00	0.00	Start Up Container		AUG 07 2018
100	Packaging	1 pcs	8/15/18	8/15/18	0.00	0.00	Packaging1-6		JRB
110	QC	1 pcs	8/15/18	8/15/18	0.00	0.00	QC4		AUG 15 2018
120	Packaging	1 pcs	8/15/18	8/15/18	0.00	0.00	Packaging3-1		AUG 15 2018
125	DC	1 pcs	8/15/18	8/15/18	0.00	0.00	DC		AUG 15 2018
130	QC21-FG	1 Ea	8/15/18	8/15/18	0.00	0.00	QC21		9-89

Part Op 110 - QC4- 100% Inspect kits for completeness

Descriptions: 120 - Identify and pack for shipping as per PPP D022-661-011 Location: _____

125 - Photocopy bluefile & type labels per PPPD022-661-011 CHG002

130 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-13A	Bolt	8 Ea (8 ea)	90-Start up Operation	5089302
D2182B	Rubber Cushion - Black (\$Per Foot)	.9300 ft (.93 ea)	90-Start up Operation	5160459
D2274	Radius Block	8 Ea (8 ea)	90-Start up Operation	5089983
D2529	Washer	8 Ea (8 ea)	90-Start up Operation	5035698
D2870	Clamp	2 Ea (2 ea)	90-Start up Operation	516245099054
D2871	Clamp	2 Ea (2 ea)	90-Start up Operation	516245099054
D3076-1	R22 Bearpaw	2 Ea (2 ea)	90-Start up Operation	5096791
MS21042L4	Nut	8 Ea (8 ea)	90-Start up Operation	5089365
NAS1149D0463J	Washer	8 Ea (8 ea)	90-Start up Operation	5089299

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-13A	8	1,645	0
	D2182B	1	4,507	0
	D2274	8	219	0
	D2529	8	1,509	0
	D2870	2	118	0
	D2871	2	146	0
	D3076-1	2	0	0
	MS21042L4	8	6,337	0
	NAS1149D0463J	8	10,475	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																											
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Description Work Order : _____ DART Aerospace Ltd. 1270 Aberdeen Street Hamlet, ON K6A 1K7 CANADA TEL: 1 613 632-6200 Email: sales@dartaero.com www.dartaerospace.com Container No: S099697 Part: D022-661-011 Job No: 181309 Serial No/Batch: S099697 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: TC STC SH02-9 Issue 1 of 1 EA 6876 SRD1493NY 02/04/26, DGAC FR				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																																																									
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Part Specifications

Specifications could not be found.

Plex 7/25/18 12:47 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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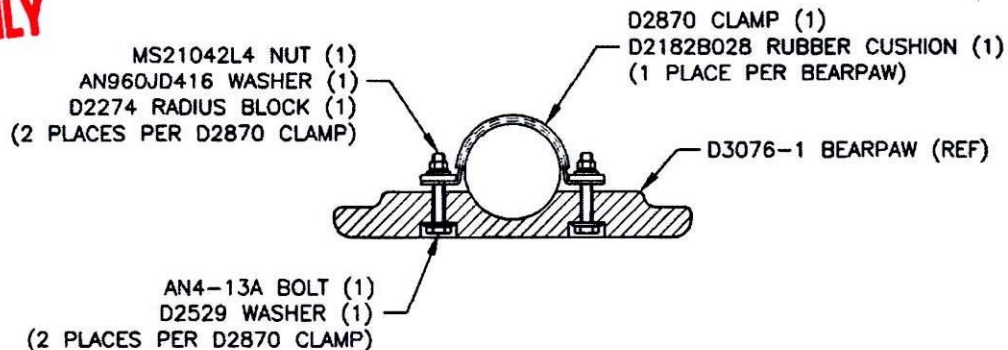
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Figure 3 - Bearpaw Installation. Forward Clamp (section view)

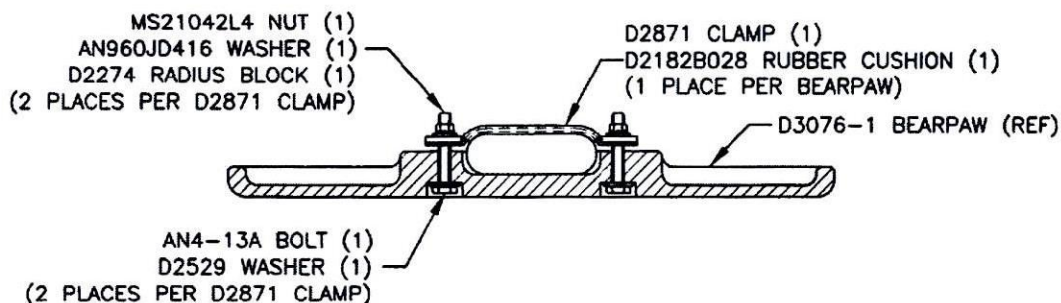


Figure 4 - Bearpaw Installation. Aft Clamp (section view)

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D022-661-011 Bearpaw Installation on model R22 aircraft	4.6 lb 2.10 kg	0.0 in 0.0 m	0.0 lb-kp 0.0 m-kp	121.1 in 3.08 m	557.1 in-lb 6.47 m-kp

5. PARTS LIST

Qty	Part Number	Description
X	D022-661-011	BEARPAW INSTALLATION
4	D2182B028	Rubber Cushion
8	D2274	Radius Block
8	D2529	Washer
2	D2870	Clamp
2	D2871	Clamp
2	D3076-1	Bearpaw
8	AN4-13A	Bolt
8	AN960JD416	Washers
8	MS21042L4	Nut (or MS21042-4)